

Date: Monday, 6/5/2006 10:57:57 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP HIGH GEAR RH
Job Number	: 27394		
Estimate Number	: 12435		
P.O. Number	: N/A	Part Number	: D205633022
This Issue	: 6/5/2006	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: DSI 9300 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 7/5/2006
Checked & Approved By	: <u>KJ 06-06-05</u>	Qty:	8 Um: Each
Comment	: Est Rev:B Added D2565-111 05-09-09 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 06 06 17

Comment: Photocopy bluefile & type labels per PPPD205-633-022	CHG001
---	--------

PER ATTACHED

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit



3.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit	Total : 32.0000 Each(s)
Spacer	
Batch: B25815	✓

4.0	D2022103	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit	Total : 16.0000 Each(s)
Spacer	
Batch: B25847 X 5	B25967 1 family

5.0	D2562011	Strut
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit	Total : 8.0000 Each(s)
Strut	
Batch: B23379 X 2	B27403 6X

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 10:57:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 27394

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: B27165

7.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: B25922 x 3 B25972 x 3 B26445 x 5

8.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: B26446 x 6 B25973 x 2

9.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: B25974 x 6 B26447 x 2

10.0

D2565109

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: B26392 x 1 B27408 x 7

11.0

D2565111

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Strut

Batch: B26648 x 1 B25976 x 3 B26448 x 4

12.0

D3437041

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Aft Strut Assembly

Batch: B27415 3mlp B27820 5mlp

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 10:57:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 27394

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D3438042

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Step Weldment Assembly

Batch: 27466

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M100851 ✓

15.0

AN46A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch: M19278 ✓

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M19278 ✓

17.0

AN411A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M17771 ✓

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M10088 ✓

19.0

AN447A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: M114781 ✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 27394

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M17566 ✓

21.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Washer

Batch: M100575 ✓

22.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Batch: M19185 ✓

23.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Nut

Batch: M19085 ✓

24.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M17694 ✓

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-021

Location: -

PPP Rev: DNA PT

AP 06/06/23 (8)

P4/7/13 (8)


PJ 6/7/18 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 26/07/04
QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 10:57:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 27394

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.19

Job Completion



u 06.07.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____

NOTE: Date & initial all entries

NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in lb -8.06 m kg	94.5 in 2.40 m	1323 in lb 15.24 m kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in lb +7.62 m kg	94.5 in 2.40 m	1247 in lb 14.40 m kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in lb -8.26 m kg	94.5 in 2.40 m	1351 in lb 15.6 m kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in lb +7.80 m kg	94.5 in 2.40 m	1276 in lb 14.74 m kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m-k g	94.5 in 2.40 m	1380 in-lb 15.94 m kg
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m-k g	94.5 in 2.40 m	1304 in-lb 15.05 m-k g

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
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

PARTS LIST

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

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APPROVED
BY: 
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DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

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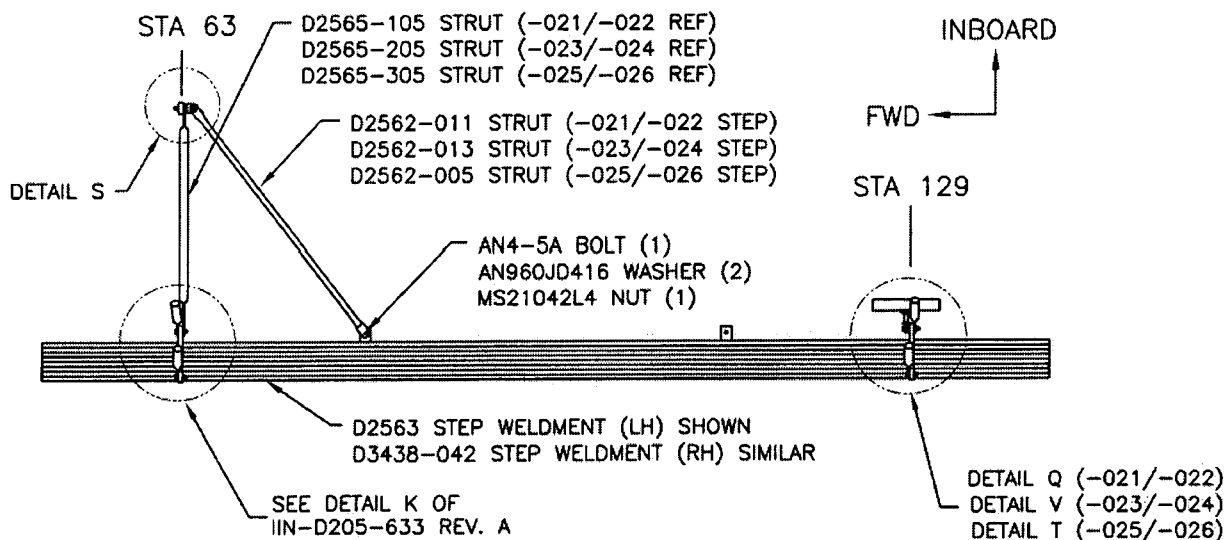
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DATE 05.08.12		TITLE SIMPLEX TANK STEP KIT	SCALE NTS

INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.



D205-633-021/-023/-025 SHOWN.

D205-633-022/-024/-026 SIMILAR

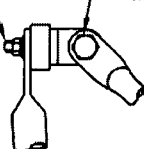
(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)

AN4-6A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)

DETAIL S

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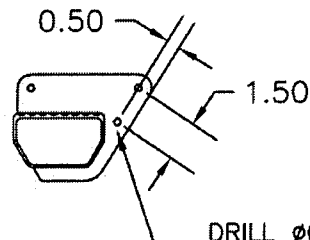
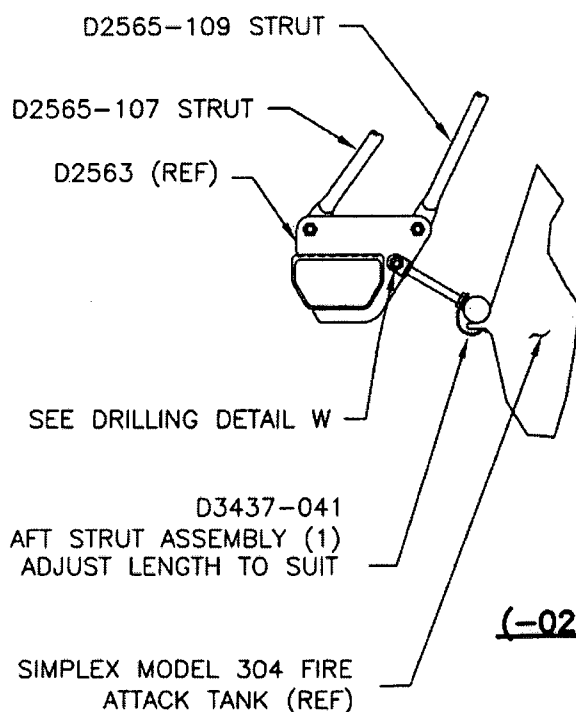
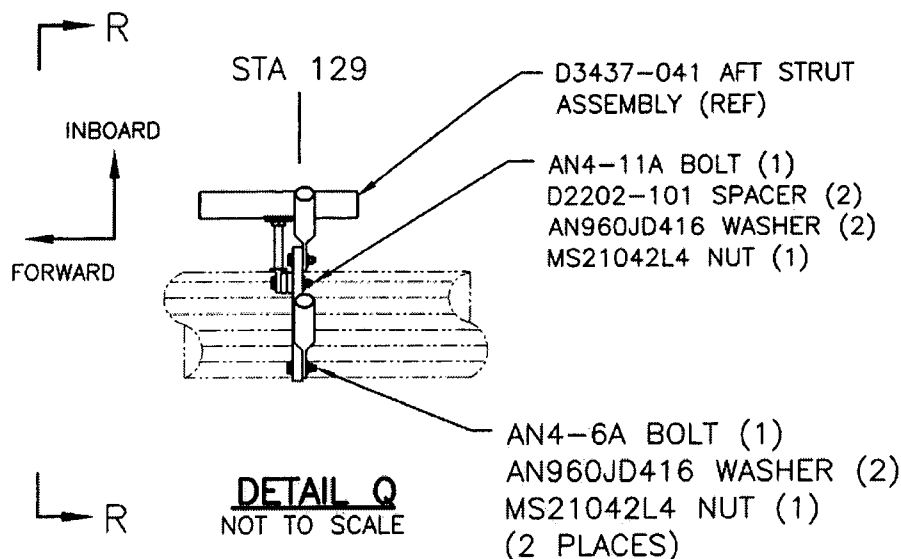
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DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



DETAIL W

DRILL $\phi 0.257$ THRU,
TOUCH UP WITH
ALODINE 1200 OR 1201
PER MIL-C-5541 AS SHOWN

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NO. *27394*

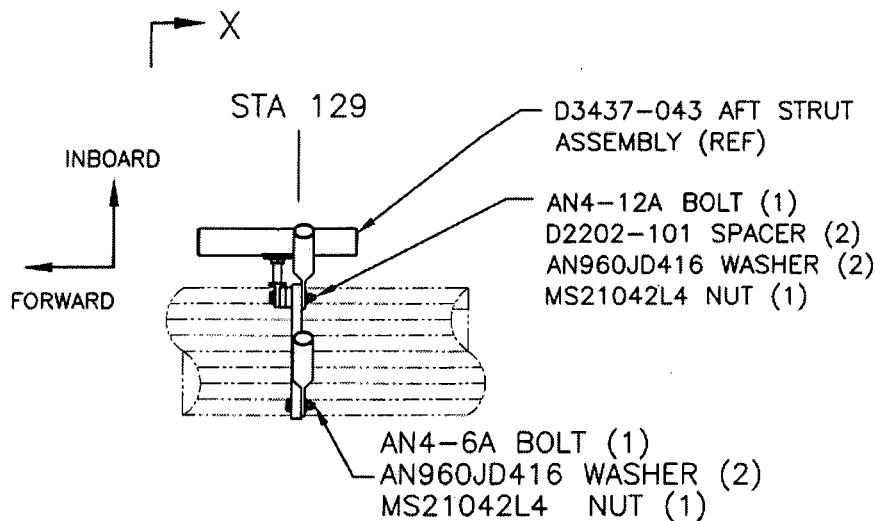
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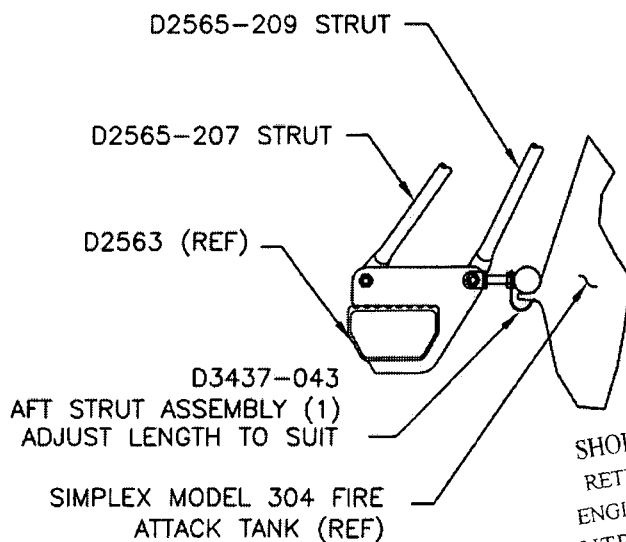
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DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



DETAIL V
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(-023/-024 STEP)

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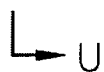
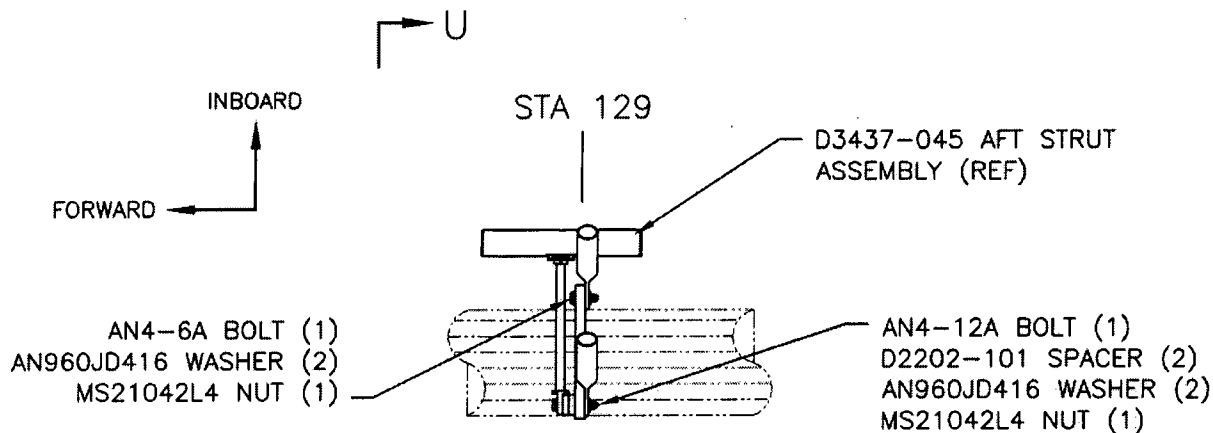
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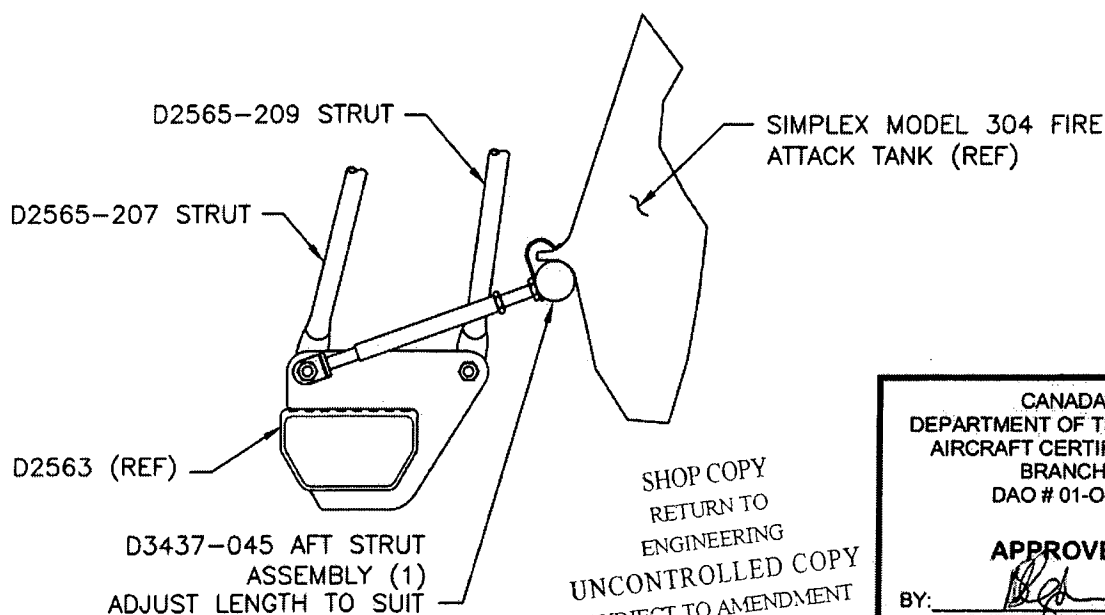
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DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



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DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

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